



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5596-1
Job Sheet 180820

Accounting Job RD17-1048-01



Part No: D5596-1

Job Qty: 5 ea

Part Name: Aft Stop Block



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/17/18

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 7/27/18

Description:

Type: R+D

Note: DWG D5596 REV:A5 IPP REV A 18.06.22 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

PRELIMINARY ISSUE

POSITIVE RECALL

EFFECTIVE JUL 17 2018

RELEASED DAS 9 DATE 10-10-03

9-89

@Rox A
per ECU
13-317

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	7/27/18	7/27/18	0.00	0.00	Start Up Machining-4		DIP 18-9-4
110	CNC Vertical Machining	5 pcs	7/27/18	7/27/18	0.42	0.83	HAAS1-4		DIP 18-9-4
120	QC	5 pcs	7/27/18	7/27/18	0.00	0.00	QC2 Machining-4		LA/DIP 18-9-4 DAS
130	QC	5 pcs	7/27/18	7/27/18	0.00	0.00	QC8 Machining-4		38
140	HandFinish	5 pcs	7/27/18	7/27/18	0.00	0.40	HandFinish1		DR 18-10-9-4
150	Powdercoat	5 pcs	7/27/18	7/27/18	0.00	0.20	Powdercoat1		DR 18-9-4
160	QC	5 pcs	7/27/18	7/27/18	0.00	0.00	QC3		18-09-07 68
170	Packaging	5 pcs	7/27/18	7/27/18	0.00	0.00	Packaging3-2	ST 536	OCT 03 2018-89
180	QC21-SA	5 Ea	7/27/18	7/27/18	0.00	0.00	QC21		DAS OCT 03 2018

Part Op 110 - -Cut Blanks 1.750" long -Machine as per Folio FC160

Descriptions: 150 - START TIME:

8:25 OUT: 6:00 FINISH: 9:00 18-83893

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X1.750	6061T6 Bar 1.000 X 1.750	.7250 ft (.145 ea)	90-Start up Operation	5050156

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X1.750	1	12	0

Part Specifications

Specifications could not be found.



Container No: S107994



Part: D5596-1

Job No: 180820

Serial No/Batch: S107994

Revision: A5

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 (613) 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 7/17/18 8:54 AM Dart.lajeunesse.marie

Date: 09/04/18

DQA: _____ Date: _____

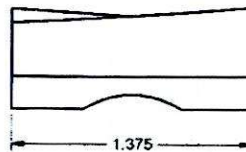
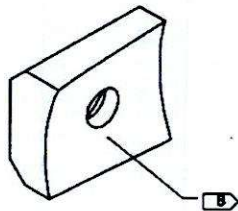
WORK ORDER NON-CONFORMANCE / UPDATE



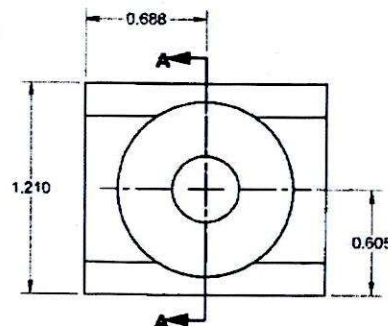
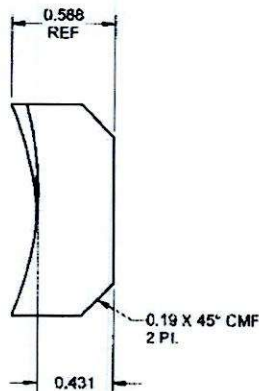
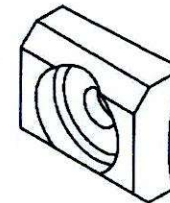
QA Closed: _____ Date: _____

Work Order update only ☐

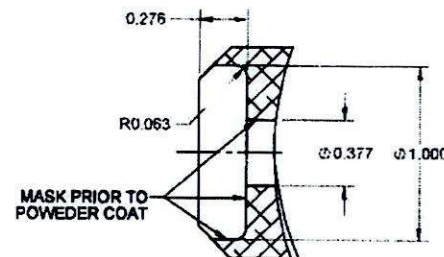
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 180720 MS
180717



D5596-1 AFT STOP BLOCK



SECTION A-A



NOTES:

- 1) MATERIAL: 6061-T6/7051/R6510/R6511/T62 ALUMINUM BAR
PER QQ-A-225/6 OR AMS-QQ-A-225/6 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/6 OR AMS-QQ-A-200/6 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M8061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs
- 8) ALL NON DIMENSIONED FEATURES PER CAD FILE D5596-1-REVA.STP

PRELIMINARY ISSUE

REV.	NEW ISSUE	DESCRIPTION	NO	DATE
DESIGN	AJS	DART AEROSPACE LTD		17.11.07
DRAWN	NO	HAWKESBURY, ONTARIO, CANADA		
CHECKED	ZF	DRAWING NO.	REV. A5	
MFG. APPR.	JFS	D5596	SHEET 1 OF 1	
APPROVED		TITLE	SCALE	
DE APPR.		AFT STOP BLOCK	NTS	
DATE	17.11.07	COPYRIGHT © 2004 BY DART AEROSPACE LTD		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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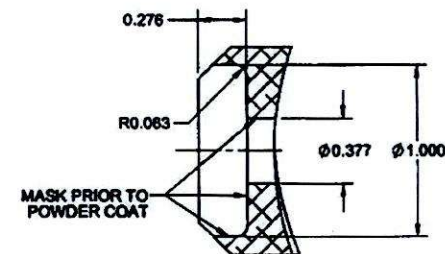
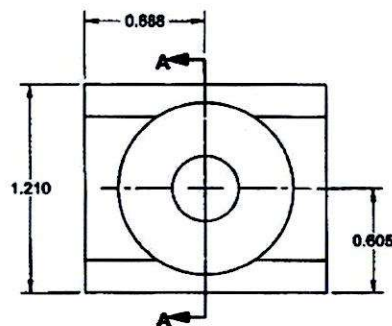
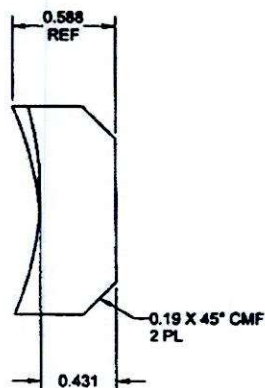
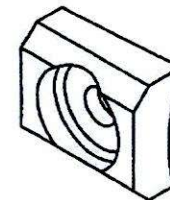
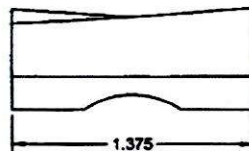
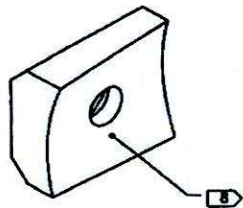


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐																																																																							
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐																																																																							
Substation ☐	Process Improvement ☐	Marks/Chatter ☐																																																																							
Past Expiry Date ☐	Manufacturing Process ☐																																																																								
Misidentified ☐	Past Due ☐																																																																								
Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																																																																							
Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																																																																							
BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																																																																							
Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																																																																							
Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																							
Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																							
Countersink ☐	Off-set ☐	Drawing ☐																																																																							
Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																							
Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																							
Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																							
OTHER : ☐																																																																									



D5596-1 AFT STOP BLOCK

SECTION A-A

NOTES:

- 1) MATERIAL: 6061-T6/7051/70510/70511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M0061T08
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 8.7
- 7) WEIGHT: 0.06 lbs
- 8) ALL NON DIMENSIONED FEATURES PER CAD FILE D5596-1-REVA.STP

RELEASED

2018 OCT 02
Sca 18-017

APPROVED

A NEW ISSUE		ZF	17.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	ZF		
CHECKED	MW		
MFG. APPR.	DD		
APPROVED	NO		
DE APPR.	CP		
DATE	17.11.07		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D5596

TITLE

AFT STOP BLOCK

REV. A

SHEET 1 OF 1

SCALE

NTS

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